

Work Order ID 59936

Thursday, June 17, 2010 12:57:14 PM



Page 1

Item ID: D2932-1

Revision ID:

Item Name: Saddle LH Out, 206

Start Date: 6/17/2010 Start Qty: 4.00

Required Date: 6/24/2010 Req'd Qty: 4.00

Reference:

Accept



Setup

Start

Stop

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date: 6-17

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2932

Rev C

100



HAAS 1

HAAS CNC vertical machine #1

HAAS CNC VERTICAL MACHINING #1

0.00

Memo

0.00

af 10.6.28

Program part number and batch number. ☐ 1-Inspect part number and batch number are programmed correctly. ☐ 2-Machine Step No 1 of Folio and visually inspect as per dwg D2932 & attached Dimension Sheet ☐ 3-Machine Step No 2 of Folio and visually inspect as per

4 0

110



Mill Conv

Conventional Milling Machine

CONVENTIONAL MILLING MACHINE

0.00

Memo

0.00

af 10.6.28

Machine Keyway and inspect per attached dimension sheet

4 0

120



QC

Quality Control

QC1- Inspect dimensions to dimension sheet

0.00

Memo

0.00

af 10.6.28

4 0

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Start

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Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130



QC

Quality Control

QC8- Inspect parts - second check

0.00

Memo

0.00

DTP 10/06/28

4

6

140



HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

0.00

Memo

0.00

H BL 10-6-29

150



Powdercoat

Powder Coating

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

Memo

0.00

START TIME:

2:35

OVEN TEMPERATURE:

320° FINISH TIME:

3:05

H. BL 10-6-29.

W/O:		WORK ORDER CHANGES					
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Reference:

Accept



Setup

Start



Stop



Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160



QC

Quality Control

QC3- Inspect Part Finish

Memo

0.00

0.00

2744

10/07/01

4

0

170



Packaging

Packaging

Identify as per dwg & Stock Location: 428

Memo

0.00

0.00

6/17/10 (4)

180



QC

Quality Control

QC21- Final Inspection - Work Order Release

Memo

0.00

0.00

10/07/01

10/07/01

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Picklist Print

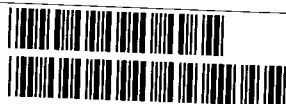
Thursday, June 17, 2010 12:57:18 PM

Page 1

Work Order ID: 59936

Parent Item: D2932-1

Parent Item Name: Saddle LH Out, 206



Start Date: 6/17/2010

Start Qty: 4.00

Required Date: 6/24/2010

Required Qty: 4.00

Comments: IPP: B□00.06.26□New DWG rev, (mpp 2069)□EC□
IPP Rev:C As per Rev C 07-03-19 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6101-003 		Manufactured	No			100	Each	40.0000	1	4			
Saddle Billet, 7075													

10.6.28

Location

MAT042

59196

Loc Qty

40

40

Loc Code

(14)

W/O:		WORK ORDER CHANGES					
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DART AEROSPACE LTD		Work Order: 57936
Description: 206 Saddle, Outboard, Left side		Part Number: D2932-1
Inspection Dwg: D2932 Rev. C		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2932 Rev. C and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.100	0.140		.126	.126	.126	.126		
B	0.100	0.140		.126	.126	.126	.126		
C	0.100	0.140		.129	.129	.129	.129		
D	0.210	0.230		.225	.225	.225	.225		
E	1.245	1.255		1.250	1.250	1.250	1.250		
F	1.245	1.255		1.250	1.250	1.250	1.250		
G	2.495	2.505		2.500	2.500	2.500	2.500		
H	0.510	0.515		.510	.510	.510	.510		
I	1.572	1.582		1.578	1.577	1.578	1.578		
J	2.495	2.505		2.500	2.500	2.500	2.500		
K	0.257	0.262		.258	.258	.258	.258		
L	0.312	0.317		.315	.315	.315	.315		
M	0.235	0.240		.238	.238	.238	.238		
N	0.100	0.140		.120	.120	.120	.120		
O	0.540	0.560		.548	.548	.548	.548		
P	0.490	0.510		.502	.502	.502	.502		
Q	3.715	3.725		3.719	3.719	3.719	3.719		
R	2.470	2.510		2.492	2.492	2.492	2.492		
S	0.240	0.270		.257	.257	.257	.257		
T	0.100	0.180		.130	.130	.130	.130		
U	1.625	1.635		1.630	1.630	1.630	1.630		
V	1.362	1.372		1.367	1.367	1.367	1.367		
W	0.316	0.321		.316	.316	.316	.316		
X	1.125	1.145		1.135	1.137	1.137	1.136		
Y	1.565	1.585		1.567	1.569	1.568	1.566		
Z	0.178	0.198		.188	.188	.188	.188		
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

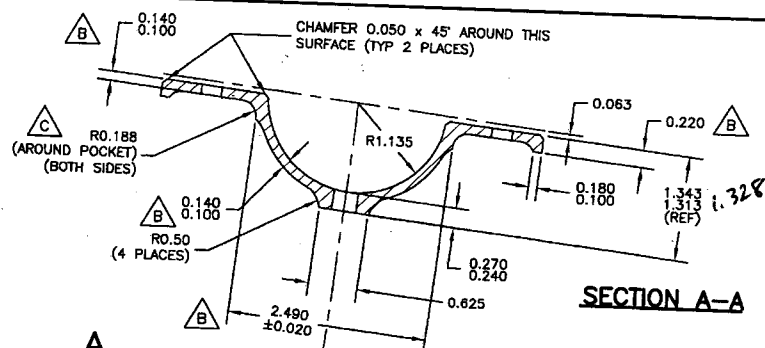
Measured by: <i>af</i>
Date: 10.6.28

Audited by: <i>DTA</i>
Date: 10/06/28

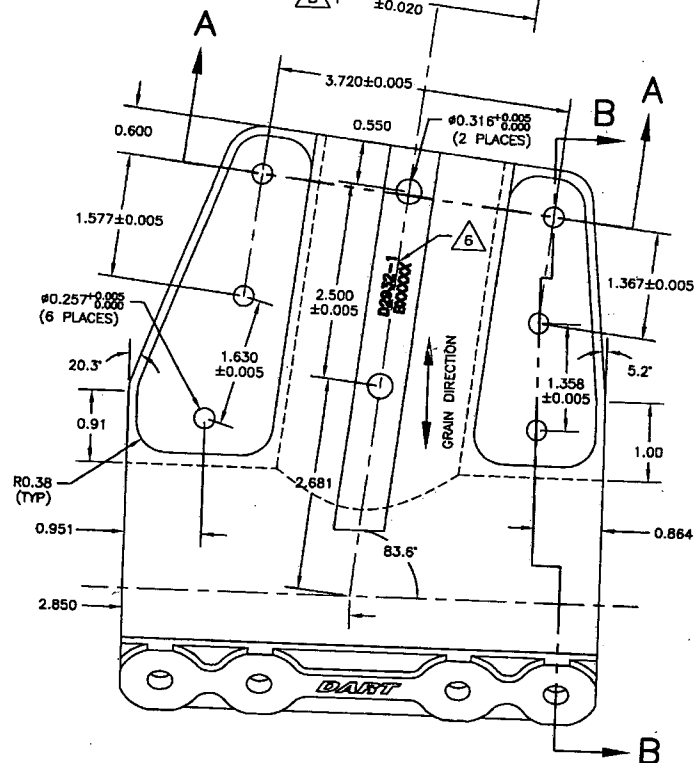
Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM	<i>[Signature]</i>

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 39936
B-106-17

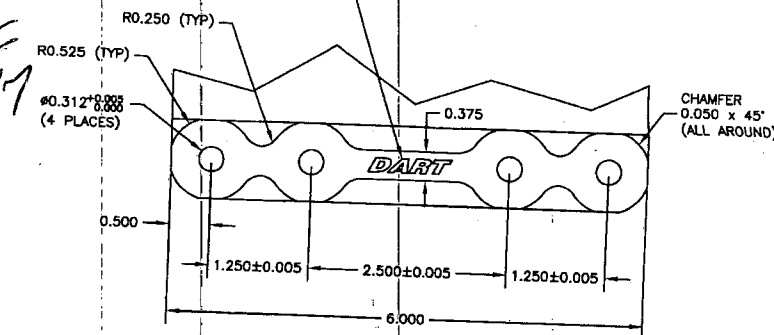
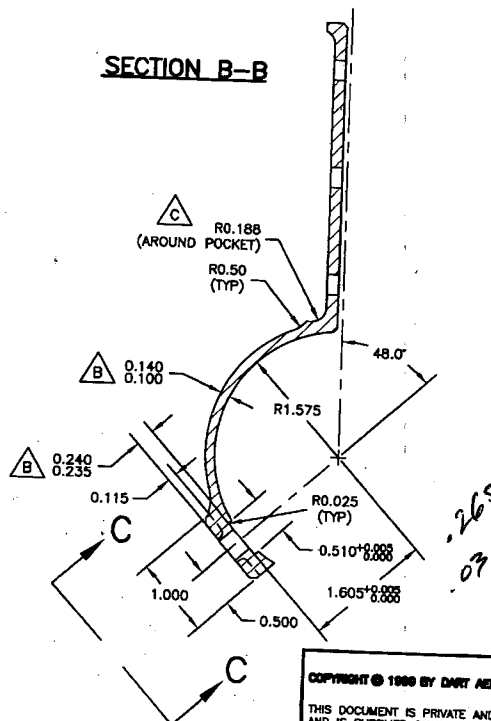
ENGRAVE DART LOGO TO MAX DEPTH
OF 0.005 WITH MIN RAD 0.250



SECTION A-A



SECTION B-B



VIEW C-C

D2932-1 LH SADDLE (SHOWN)
D2932-2 RH SADDLE (OPPOSITE)

- NOTES:
- 1) MATERIAL: ALUMINUM 7075-T7351 (QQ-A-250/12)
(MAKE FROM D8101-003 SADDLE BILLET, 7075)
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
 - 3) BREAK ALL SHARP EDGES 0.010 TO 0.020
 - 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
 - 5) ALL DIMENSIONS ARE IN INCHES
 - 6) ENGRAVE PART AND BATCH NUMBER IN THIS AREA 0.010 TO 0.015 DEEP

C	06.11.09	R0.188 WAS R0.30 TO R0.25
B	00.05.29	CHANGED GEOMETRY AND MATERIAL
A	99.10.29	NEW ISSUE
DESIGN	BY	DRAWN BY
CHECKED	PH	APPROVED
DATE	06.11.09	TITLE
		SADDLE OUTSIDE

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DART AEROSPACE USA, INC.

DART DART AEROSPACE USA, INC.
BELLINGHAM, WA

DRAWING NO. D2932
REV. C
SHEET 1 OF 1

SCALE 2:3

RELEASED

07-02-02

W/O:		WORK ORDER CHANGES					
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